

Tuesday, 11/29/2005 6:48:17 PM
Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25035
Estimate Number : 10467
P.O. Number : N/A
This Issue : 11/29/2005 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : N/A
Written By : SEE ABOVE USER & DATE
Checked & Approved By :
Comment : Created By Auto Work Order

Drawing Name : FWD TUBE ASSEMBLY
Part Number : D3391021
Drawing Number : D3391 REV B Rev. D
Project Number : N/A PH 05.03.02
Drawing Revision : B
Material : N/A
Due Date : 12/21/2005 Qty: 4 Um: Each

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 D6013047 SKIDTUBE MAT'L



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
SKIDTUBE MAT'L

Pick:

Qty Part Number Description
1 D6013-047 Extrusion

Batch

B2B935

DP 06-1-12 (5)

Tools:

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
Cut extrusion to 46.52 +0.010 -0.020

DP 06-1-12 (5)

Tools:

3.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D3391

DP 06-1-12/06-2-28 (5)

Tools:

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

Id 02-20 5

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 25035

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. D & Dwg D3391 Rev. D

Identify as D3391-1

2-Deburr

ml/SD 06.03.03 4 TTD

Tools:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/03/04 4

Tools:

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/03/0 4

Tools:

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Drill and c'sink float bag holes as per Dwg D3391 using DT8798

Drill wearplate holes as per Dwg D3391

Deburr

> DP06-3-23 (4)

Tools:

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1 85 06-03-23 (3)

Tools:

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/23 (3)
DL 06/04/13 (1)

Tools:

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 25035

Part Number: D3391021

Job Number:



Seq. #: Machine Or Operation:

Description:

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Tools:

12.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Tow Cap Assembly

Pick:

Qty
1

Part Number
D3401-041

Description
Tow Cap

Batch

B25548

Tools:

13.0

AN3C4A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Pick:

Qty
4

Part Number
AN3C4A

Description
Bolt

Batch

M19185

Tools:

14.0

NAS1330C3KB166

Rivnut



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Rivnut

Pick:

Qty
24

Part Number
NAS1330C3KB166

Description
Insert

Batch

M19354

Tools:

15.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Pick:

Qty
4

Part Number
NAS1515H3

Description
Washer

Batch

M19185

Tools:

15.1

4

AN160C10L

M18822

M18822

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 25035

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install inserts and Tow Cap as per Dwg D3391
Identify as D3391-021

M DL 06/04/04
DL 06/04/07

(3)

Tools:

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 06/04/04

(3)

Tools:

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

FC 06 04 07 (3)

Tools:

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DL 06/04/10
DL 06/04/21 (3)

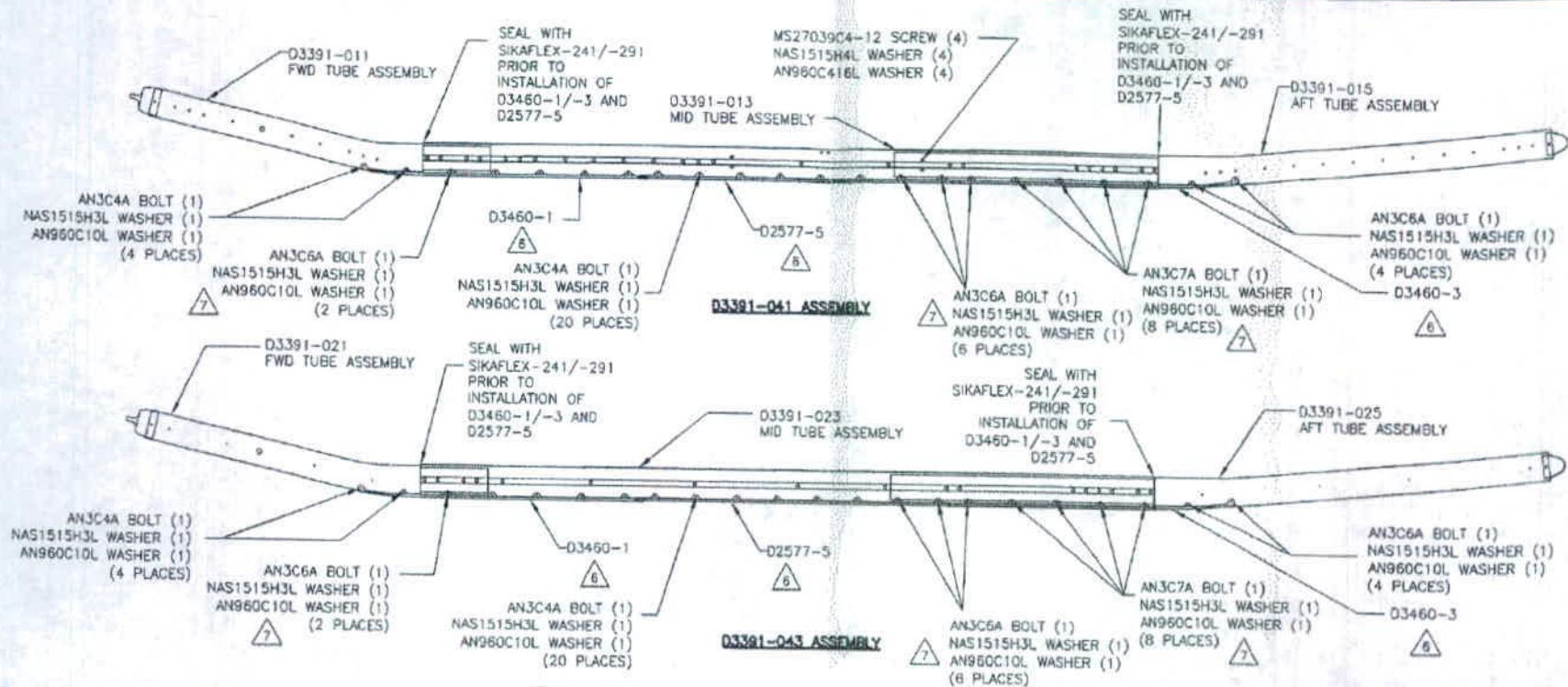
Tools:

Job Completion



U 06.04.07

U 26.04.21



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	NAS1515H3L	WASHER
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3460-3	WEARSHOE

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.
- 6) APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- 7) DO NOT TORQUE, HAND TIGHTEN ONLY

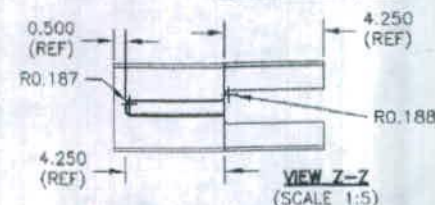
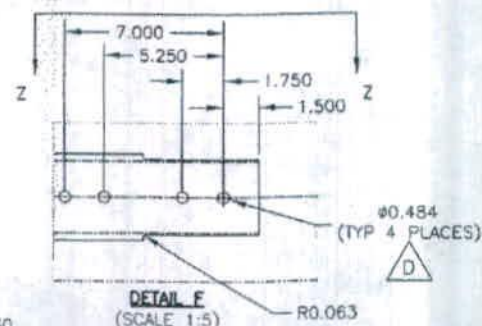
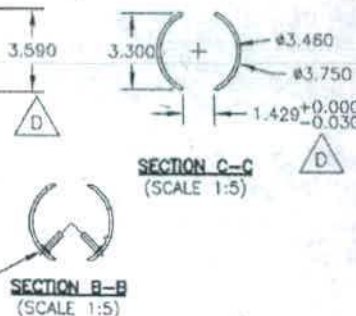
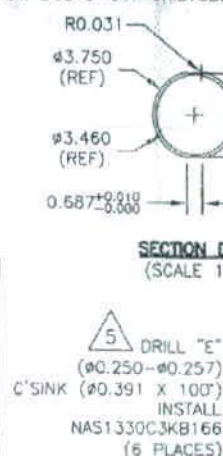
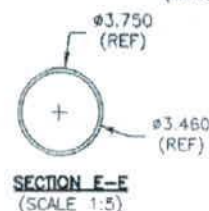
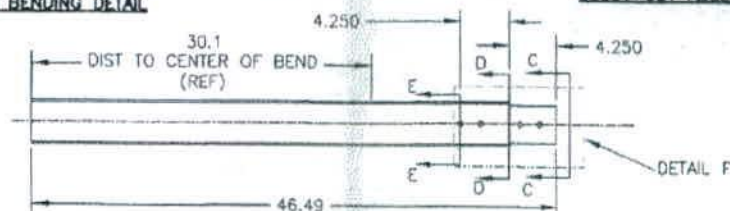
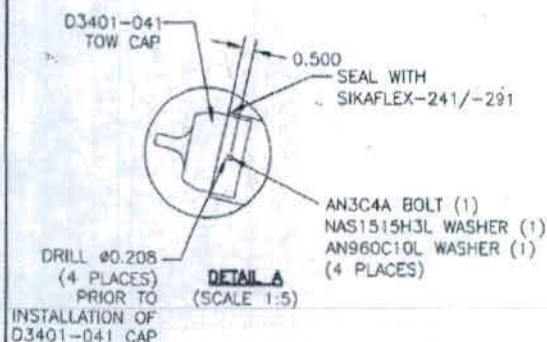
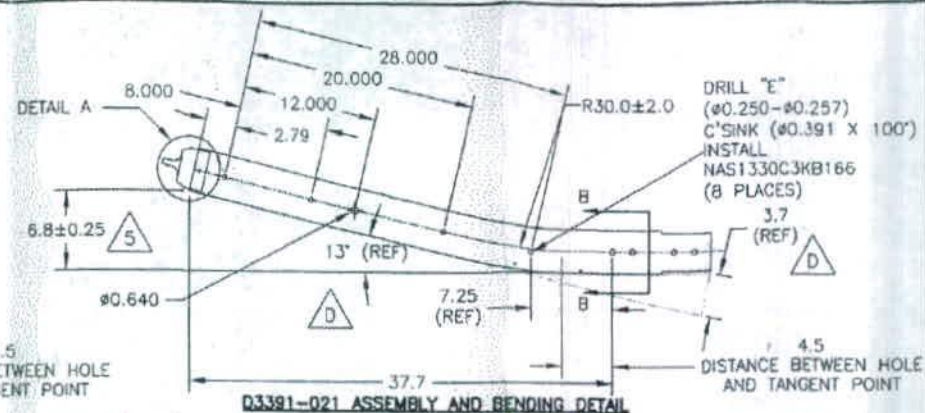
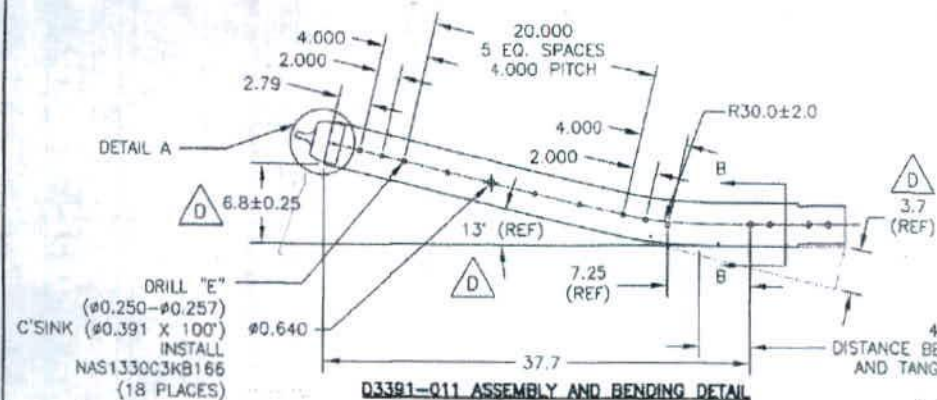
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DESIGN	PH	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
CHECKED	PH	05.09.27	LENGTHEN AFT EXTENSION
DATE	06.01.23	05.06.10	DRAWING UPDATES
		05.02.07	NEW ISSUE
DART AEROSPACE USA, INC.			
DRAWING NO. D3391			REV. 0
TITLE 412 FLOAT SKIDTUBE			SHEET 1 OF 5
			SCALE NTS

RELEASED

06-01-27

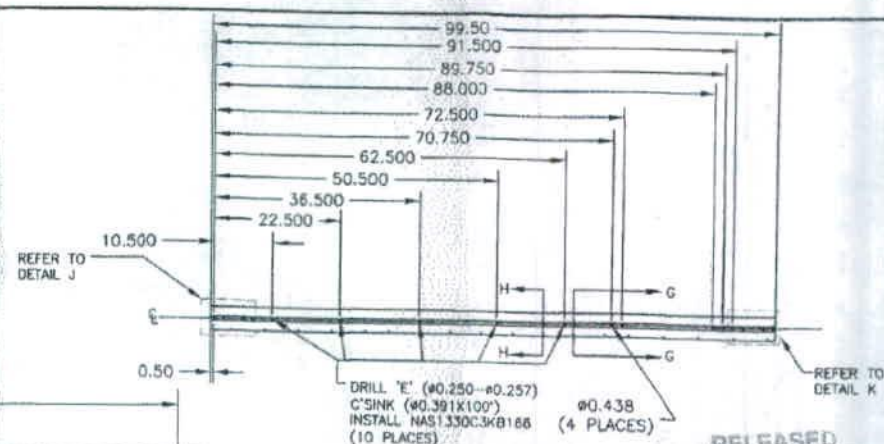
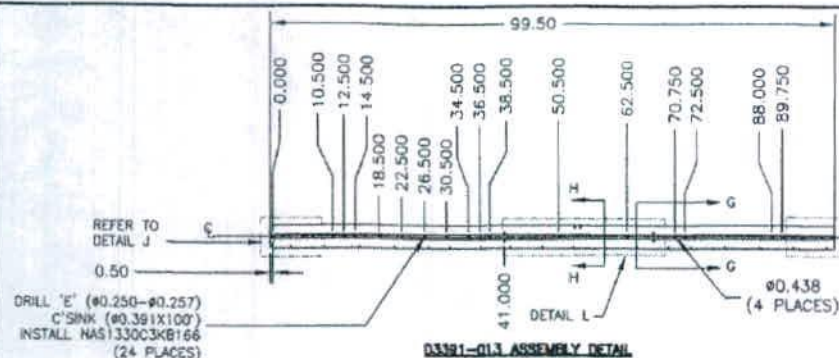


D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER
24	14	NAS1330C3KB166	INSERT

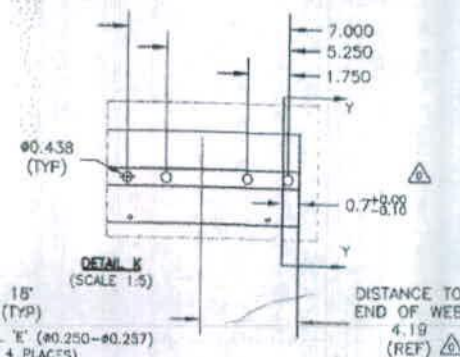
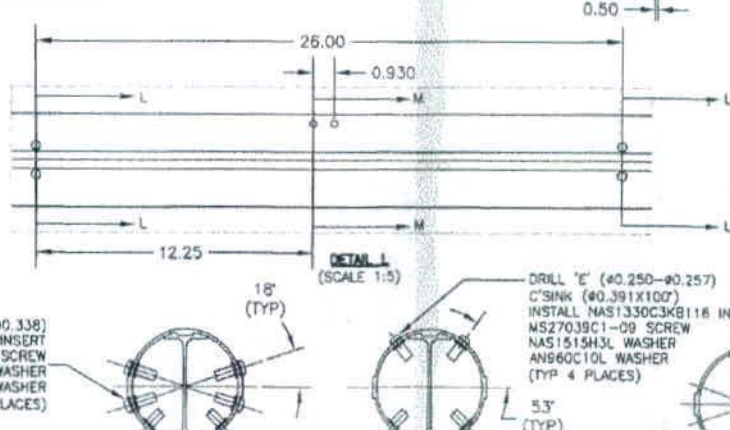
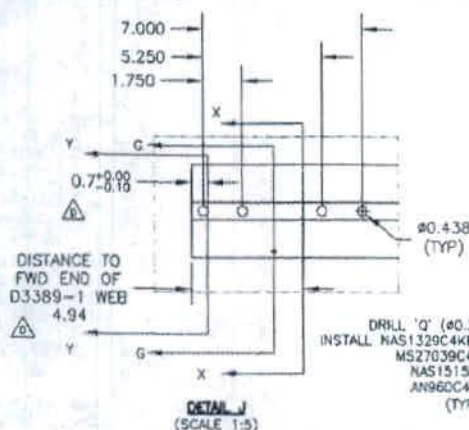
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CHECKED	PH	APPROVED	PH	
DATE	06.01.23	DRAWING NO.	D3391	REV. D SHEET 2 OF 3
TITLE	412 FLOAT SKIDTUBE	SCALE	1:10	



RELEASED

D3391-023 ASSEMBLY DETAIL



D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

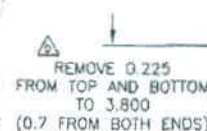
QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

SECTION L-L (SCALE 1:4)



SECTION X-X (SCALE 1:2)

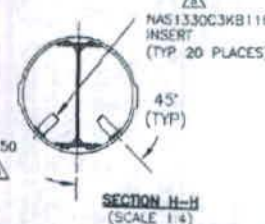
SECTION M-M (SCALE 1:4)



SECTION U-U (SCALE 1:4)



SECTION G-G (SCALE 1:4)



SECTION H-H (SCALE 1:4)

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CHECKED PH
DATE 06.01.23

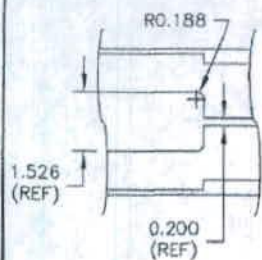
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APPROVED PH
TITLE 412 FLOAT SKIDTUBE

DART AEROSPACE USA, INC.

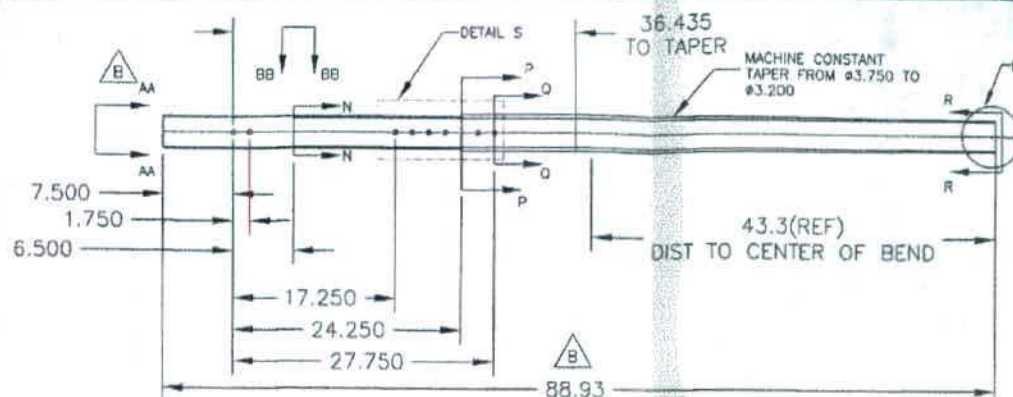
DRAWING NO. D3391
SHEET 3 OF 5
SCALE 1:20

D3391-013/-023 MID TUBE ASSEMBLY

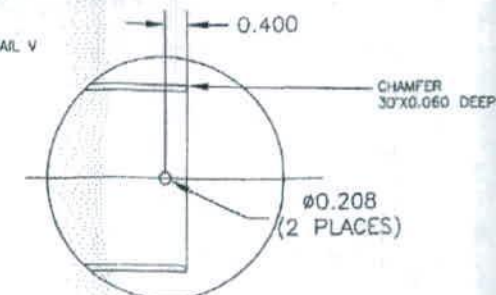
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015



VIEW BB-BB
(SCALE 1:3)



03391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

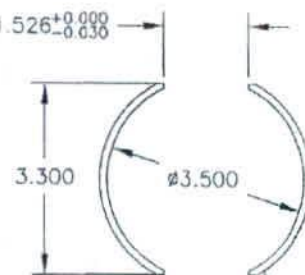


DETAIL V
(SCALE 1:2)

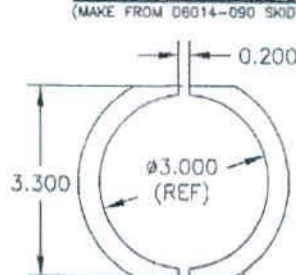
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06-01-27

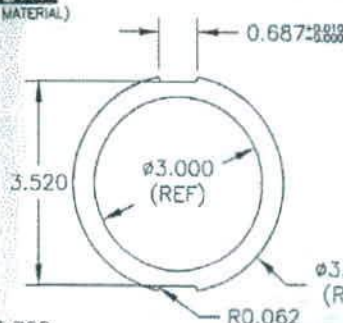
1.526^{+0.000}_{-0.030}



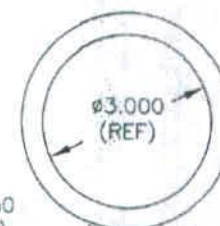
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(SCALE 1:2)



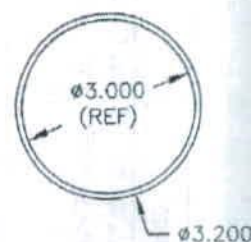
SECTION N-N
(SCALE 1:2)



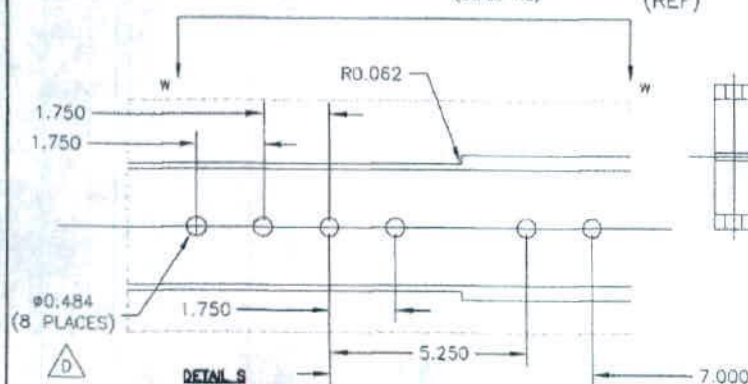
SECTION P-P
(SCALE 1:2)



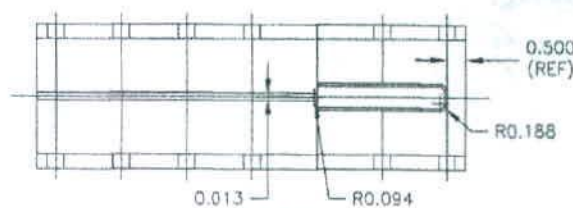
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



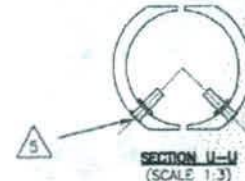
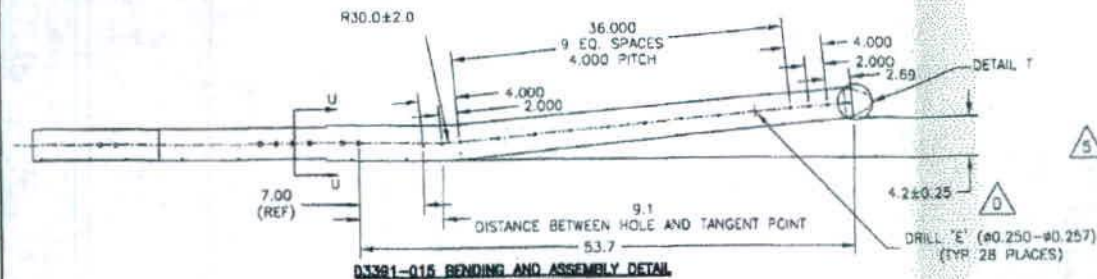
VIEW W-W
(SCALE 1:3)

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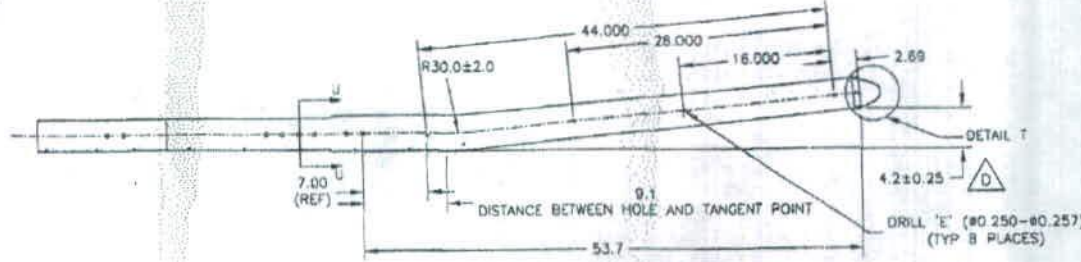
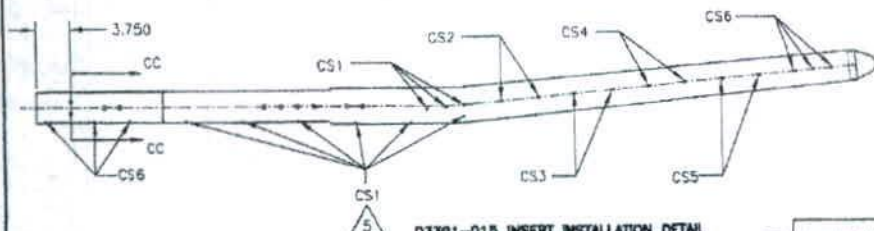
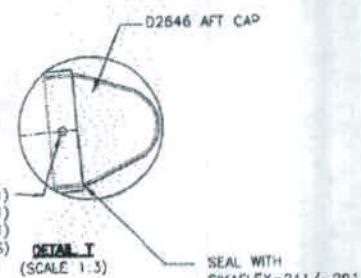
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CHECKED	PH	APPROVED	PH	PORT KANAWA, WA
DATE	06.01.23	DRAWING NO.	03391	REV. 0
TITLE	412 FLOAT SKIDTUBE	SHEET	4 OF 5	SCALE
				1:12

RELEASED
06-01-23



AN3C4A BOLT (1)
NAS1515HJL WASHER (1)
AN960G10L WASHER (1)
(2 PLACES)

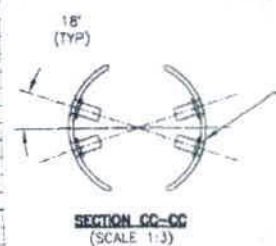


C'SINK AND INSTALL AESS10KBXXX AND/OR
NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS
FOLLOWS

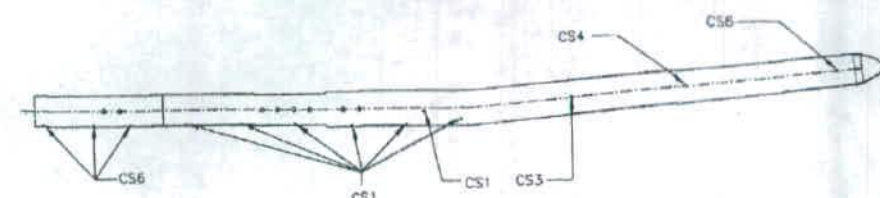
HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	AESS10KB366
CS2	4		Ø0.391	AESS10KB366
CS3	4	2	Ø0.391	NAS1330C3KB310
CS4	4	2	Ø0.391	NAS1330C3KB266
CS5	4		Ø0.391	NAS1330C3KB216
CS6	12	8	Ø0.391	NAS1330C3KB166

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D8C14-090	AFT TUBE
1	1	D2648	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB310	INSERT
4	2	NAS1330C3KB266	INSERT
4	2	NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515HJL	WASHER
2	2	AN960G10L	WASHER



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)



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CHECKED	APPROVED	DRAWING NO. D3391	REV. 0	SHEET 5 OF 5
DATE 06.01.23	TITLE 412 FLOAT SKIDTUBE	SCALE 1:13		

